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D2561

Job Sheet 209961



Part No: D2561

Job Qty: ¹⁶12 pcs ^{DAS}9-88

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/20/20

Job Tracking No:

Due Date: 6/10/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP C 00.05.19 Added inspect level 8 EC IPP Rev:D Now on Waterjet 06-06-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	6/10/20	6/10/20	0.01	0.64	Waterjet - Flow		on 20/05/20
							Waterjet - Omax		
120	QC 2	12 pcs	6/10/20	6/10/20	0.00	0.00	QC 2 - 1		on 20/05/20
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
140	QC 8	12 pcs	6/10/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
150	Packaging 3-1 - Stock - B4B	12 pcs	6/10/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B

DAS
MAY 28 2020 40
9-89

5/20/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 22 - B4B	DAS	
				Packaging 3 - 23 - B4B	84	WA003
				Packaging 3 - 24 - B4B	9-89	
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
160 QC 21 - SA	12 pcs	6/10/20	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70	DAS	
				QC 21 - SA - 9	21	JUN 01 2020

Part Op 100 - 1-Cut as per Dwg D2561 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - (Identify as per dwg & Stock Location:) *** STOCK IN STEP CELL*** LOCATION WA003
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM			
Part / Item	Component Name	Quantity	Operation
M6061T6S.250	6061T6 Sheet .250	1.6800 sf (.14 ea)	100-Waterjet - Flow - 1
			Container 5225345

Job Allocations			
Operation	Component Part	Required	Inventory
100-Waterjet - Flow - 1	M6061T6S.250	2	30
			Allocated 0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Plate	0.500inches ± 0.010	0.510		
2	Lug Plate	2.525inches ± 0.010	0.490		
3	Lug Plate	3.975inches ± 0.010	2.535		
4	Lug Plate		2.515		
			3.985		
			3.965		
5	Lug Plate	0.257inches + 0.005	0.262		
		- 0.000	0.257		
6	Lug Plate	4.525inches ± 0.010	4.535		
			4.515		
7	Lug Plate	5.025inches ± 0.010	5.035		
			5.015		
		0.250inches ± 0.030	0.280		
			0.220		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (QS1042)			
Date: _____ Sequence #: _____		QTY Affected: _____				
Description Work Order Deviation		Disposition				
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width: 100%;"> <tr> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ </td> <td style="width: 33%;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> <td style="width: 33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ </td> </tr> </table> Other/Details: _____		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				
		Completed By				
		Lead hand / Supervisor				
		QC / QA Coordinator				